

20

DART AEROSPACE LTD	Work Order:	20770
Description: Blade	Part Number:	D2741
04.03.03 18-UP		
Drawing: D2741 Rev. B2	Qty:	30

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	AF	04.04.28	30
2	METAL	Cut blanks 13.850" long +0.063" -0.000" Material: 4130 steel bar 0.50" x 3.00" Batch: 1714691	MF	04/04/28	30
3	CNC CELL	Machine per folio FA108	BF	04/05/10	30
4	QC	Inspect Level 2	EF	04/05/10	30
5	QC	Inspect Level 8	AB	04.05.18	30
6	METAL	Deburr	IB	04.05.18	30
7	METAL	Bend per Dwg D2741	IB	04.05.18	30
8	QC	Inspect Level 5	EC	04.05.25	30
9	PURCHASING	Issue P/O: 2006507 Harden material as per Dwg D2741 Min. Ultimate Tensile Strength = 152 ksi (34-40 HRC) Min. Yield Tensile Strength = 141 ksi Test report or Certification required	UA	04.06.08	30
10	RECEIVING	Receive and Inspect for transit damage Ensure Test report or Certification attached	UC	04/06/23	30
11	QC	Inspect Level 5	AB	04.06.24	30
12	FINISHING	Powder Coat White (Ref. 4:3.5.2) per QSI 005 4.3	MM	04.07.05	30
13	QC	Inspect Level 3	Z	04.07.06	30
14	STORES	Identify and stock	UC	04/07/07	30
15	EXPEDITING	Close W/O Cost / part 54.77 54.68 04/07/09 (30)	AF	04.07.12	30

Rev	Date	Change	Revised By	Approved
A	98.09.10	New Issue	DS/CP	
B	99.03.22	Material hardened after counterbore.	DM	
C	00.11.01	Removed P/O for Powder Coat - in house process	EC	
D	00.11.15	Removed P/O turning - in house process	EC	

RELEASED

EC 00.11.20

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

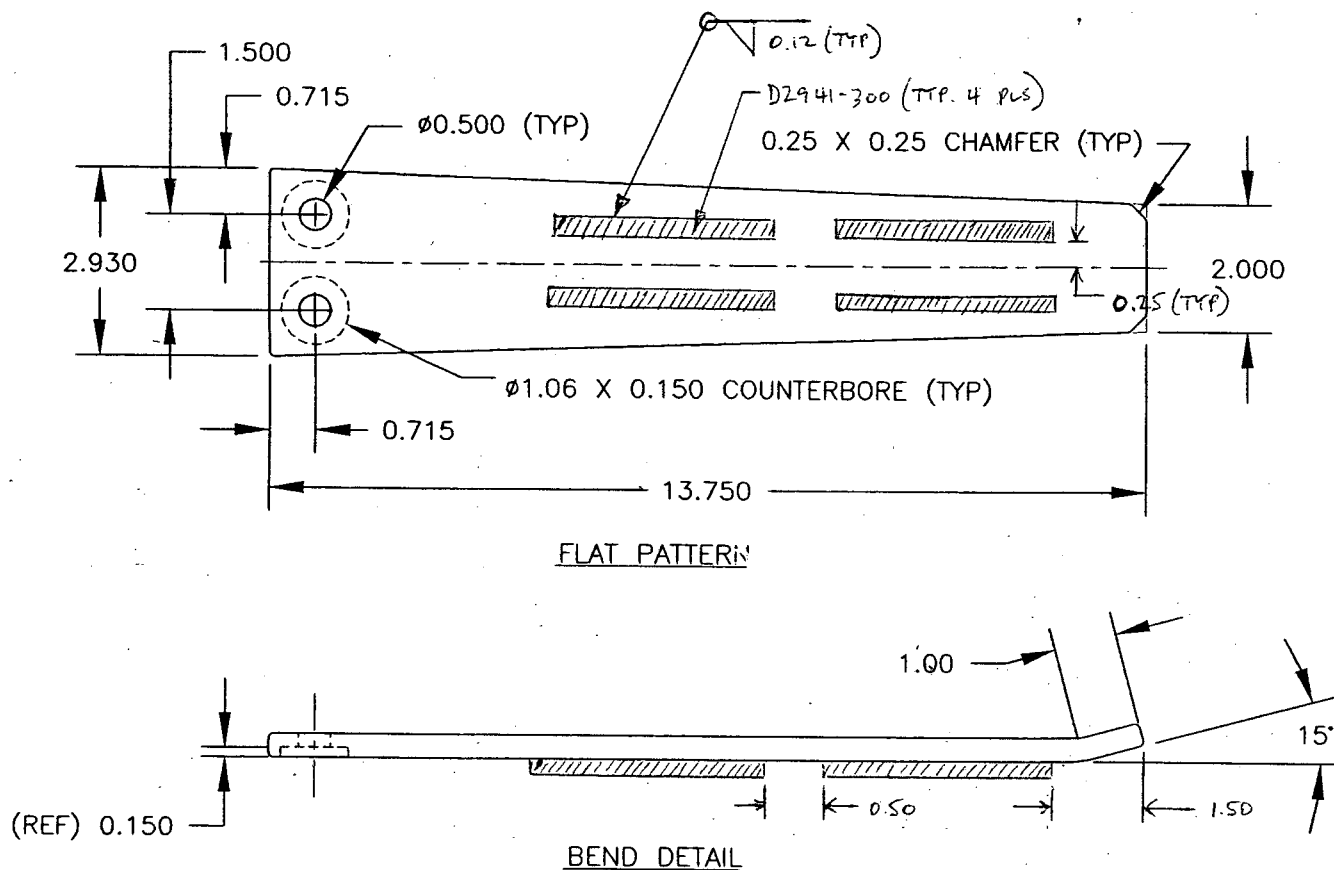
QA: N/C Closed: _____ Date: _____

DART



RELEASED
98-11-03 DS

DESIGN BY	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA	SHEET 1 OF 1
DATE	TITLE	BLADE	SCALE
98.09.01	98.04.16	NEW ISSUE	1:3
B	98.09.01	CHANGE C'SINK TO C'BORE	
B1	01.01.31	ADD 2941-041/-043 OPTIONS	
B2	01.02.25	ADD ROCKWELL HARDNESS	



#01.02.25
CP 01.02.26
B2

MATERIAL: AISI 4130 STEEL 0.375 THICK
 MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)
 MIN. YIELD TENSILE STRENGTH = 141 ksi
 FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 BREAK ALL SHARP EDGES 0.030 TO 0.060

#01.01.31
CP 01.01.31
 { TO MAKE D2741-041, WELD 2941-300 (4) AS SHOWN ABOVE. REMOVE POWDER COAT FROM SURFACE OF D2941-300
 TO MAKE D2741-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 20770

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 27, 2004
03:08 pm

Work Order No : 0020770
Project Name : D2741
Project For : WK420
Work Order Type : Main
Main WO Number :
House Part Number : D2741
Description : Blade
Manufactured : Yes
Amount Req'd : 30
Amount Done : 0
Start Date : 04-27-04
Est Finish Date : 05-12-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



VAC AERO
INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 55064-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

06/18/2004

MM / DD / YYYY

PAGE: 1

BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
06/18/2004		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
87955		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2741	BLADE	EA	30	30	
<p>Process Specifications: HARDENED PER DWG. D2741 TO 152 KSI MINIMUM MATERIAL: 4130</p>					
<div>100% HARDNESS TESTED 37 / 38 HRC</div> <p>SF</p>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT



HEAT